

RUSH



Dart Aerospace Ltd.  
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Canada

Tel (613) 632-5200

D3639-3

Job Sheet 174429



Part No: D3639-3

Job Qty: 8 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/15/18

Job Tracking No:

Due Date: 3/30/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off           |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|--------------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                    |
| 90    | Start up Operation | 8 Ea  | 3/29/18    | 3/29/18  | 0.00      | 0.00    | Start Up Waterjet     |           | SL 8/03/22         |
| 100   | Waterjet           | 8 pcs | 3/29/18    | 3/29/18  | 0.00      | 1.04    | Waterjet1             |           | SL 15/03/22        |
| 110   | QC                 | 8 pcs | 3/29/18    | 3/29/18  | 0.00      | 0.00    | QC2 Waterjet-2        |           | SL 08/03/22        |
| 120   | QC                 | 8 pcs | 3/29/18    | 3/29/18  | 0.00      | 0.00    | QC8-3                 |           | 38                 |
| 130   | Brake NC           | 8 pcs | 3/29/18    | 3/29/18  | 0.00      | 0.45    | Brake NC 2            |           | 9-89 SH            |
| 140   | QC                 | 8 pcs | 3/29/18    | 3/29/18  | 0.00      | 0.00    | QC5                   |           | EB                 |
| 150   | HandFinish         | 8 pcs | 3/30/18    | 3/30/18  | 0.00      | 0.74    | HandFinish1           |           | SADAS 04/03/23     |
| 160   | QC                 | 8 pcs | 3/30/18    | 3/30/18  | 0.00      | 0.00    | QC7-2                 |           | 11 APR 03 2018     |
| 170   | Packaging          | 8 pcs | 3/30/18    | 3/30/18  | 0.00      | 0.00    | Packaging3-1          | 5X234A    | 9-89 APR 04 2018   |
| 180   | QC21-SA            | 8 Ea  | 3/30/18    | 3/30/18  | 0.00      | 0.00    | QC21                  |           | DAS 21 APR 04 2018 |

Part Op 100 - 1-Cut as per Dwg D3639 Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Form as per Dwg D3639

140 - QC5- Inspect part completeness to step on W/O

150 - Chemical Conversion Coat per QSI005 4.1

160 - QC7-Inspect Chemical Conversion Coat

170 - Identify as per dwg &amp; Stock Location:

180 - QC21- Final Inspection - Work Order Release

## Job BOM

| Part / Item  | Component Name     | Quantity              | Operation             | Container |
|--------------|--------------------|-----------------------|-----------------------|-----------|
| M2024T3S.050 | 2024-T3 .050 Sheet | 3.4217 sf (.42771 ea) | 90-Start up Operation |           |

## Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | M2024T3S.050   | 3        | 112       | 0         |

## Part Specifications

Specifications could not be found.



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Container No: S054005



Part: D3639-3

Job No: 174429

Serial No/Batch: S054005

Revision:  
Inspector:

Date: 03/22/18

006

|                              |               |                             |
|------------------------------|---------------|-----------------------------|
| <b>DART AEROSPACE LTD</b>    |               | <b>Work Order:</b> 174429   |
| <b>Description:</b> Doubler  |               | <b>Part Number:</b> D3639-3 |
| <b>Inspection Dwg:</b> D3639 | <b>Rev:</b> A | <b>Page 1 of 1</b>          |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.625            | +0.008/-0.001 | 0.625            | 1      |        | uDC-01               |          |
| Ø0.191            | +0.005/-0.001 | 0.192            | 1      |        |                      |          |
| Ø0.098            | +0.004/-0.001 | 0.099            | 1      |        |                      |          |
| 0.45              | +/-0.030      | 0.454            | 1      |        |                      |          |
| 1.350             | +/-0.010      | 1.349            | 1      |        |                      |          |
| 2.25              | +/-0.030      | 2.25             | 1      |        |                      |          |
| 3.15              | +/-0.030      | 3.15             | 1      |        |                      |          |
| 4.05              | +/-0.030      | 4.05             | 1      |        |                      |          |
| 4.95              | +/-0.030      | 4.95             | 1      |        |                      |          |
| 5.85              | +/-0.030      | 5.85             | 1      |        |                      |          |
| 6.75              | +/-0.030      | 6.75             | 1      |        |                      |          |
| 7.65              | +/-0.030      | 7.65             | 1      |        |                      |          |
| 8.55              | +/-0.030      | 8.55             | 1      |        |                      |          |
| 9.350             | +/-0.010      | 9.351            | 1      |        |                      |          |
| 9.45              | +/-0.030      | 9.45             | 1      |        |                      |          |
| 10.350            | +/-0.010      | 10.350           | 1      |        |                      |          |
| 11.25             | +/-0.030      | 11.25            | 1      |        |                      |          |
| 12.15             | +/-0.030      | 12.15            | 1      |        |                      |          |
| 12.85             | +/-0.030      | 12.85            | 1      |        |                      |          |
| 13.86             | +/-0.030      | 13.86            | 1      |        |                      |          |
| 13.96             | +/-0.030      | 13.96            | 1      |        |                      |          |
| 0.805             | +/-0.010      | 0.807            | 1      |        |                      |          |
| 1.00              | +/-0.030      | 1.00             | 1      |        |                      |          |
| 2.100             | +/-0.010      | 2.101            | 1      |        |                      |          |
| 3.30              | +/-0.030      | 3.30             | 1      |        |                      |          |
| 2.000             | +/-0.010      | 2.001            | 1      |        |                      |          |
| 2.590             | +/-0.010      | 2.590            | 1      |        |                      |          |

|                        |                          |                            |     |
|------------------------|--------------------------|----------------------------|-----|
| <b>Measured by:</b> SC | <b>Audited by:</b> 38    | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b> 18/03/22  | <b>Date:</b> MAR 27 2018 | <b>Date:</b>               | N/A |

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 07.10.24 | New Issue | KJ/EC/DD   |          |